

Date: Thursday, 11/23/2006 11:56:28 AM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: CLEVIS
Job Number	: 29677		
Estimate Number	: 10574		
P.O. Number	: N/A	Part Number	: D34531
This Issue	: 11/23/2006 S.O. No. : N/A	Drawing Number	: D3453 REV A
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A Type : MACHINED PARTS	Drawing Revision	: A
Previous Run	: 28188	Material	: N/A
Written By	: <u>JA 061123</u>	Due Date	: 12/5/2006
Checked & Approved By	: <u>JA 061123</u>	Qty:	16 Um: Each
Comment	: A 05.09.07 New issue EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M304R1250	Inventory
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Comment: Qty.: 22800 f(s)/Unit Total : 2.3040 f(s)
 Material: AISI 304 SS Round Bar Ø1.250
 (M304R1.250)
 Batch: 101549

D.F. 05/12/05

2.0	HARDINGE	HARDINGE CNC LATHE SMALL
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Comment: HARDINGE CNC LATHE SMALL
 1-Turn as per Folio FA577 Rev: A & Dwg D3453 Rev: A
 2- Deburr as per dwg D3453

J.F. 06/12/05 (16)

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

J.F. 06/12/05 (16)

4.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1
 1-Mill as per Folio FA577 Rev: A & Dwg D3453 Rev: A
 2- Deburr as per dwg 3453

J.F. 06/12/13 (16)

5.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

J.F. 06/12/13

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 06/12/19

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 11/23/2006 11:56:29 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: CLEVIS

Job Number: 29677

Part Number: D34531

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

MILLING CONV.

CONVENTIONAL MILLING MACHINE



J.F. DSP 06/12/16



Comment: CONVENTIONAL MILLING MACHINE

1- Drill as per dwg D3453

2-Deburr as per dwg D3453

7.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE J.F. DSP 06/12/16

8.0

QC8

SECOND CHECK



Comment: SECOND CHECK

J.G 06/12/16 16

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 57436

06/12/18

(16)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



(16)

Comment: FINAL INSPECTION/W/O RELEASE

06/12/18

Job Completion



C Loc 12/18

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	29677
Description: Clevis		Part Number:	D3453-1
Inspection Dwg: D3453	Rev: A	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
3.26	+/-0.030	3.265	✓			
1.00	+/-0.030	.998	✓			
1.550	+/-0.010	1.553	✓			
0.500	+0.010/-0.000	.504"	✓			
Ø0.438	+0.006/-0.001	.439"	✓			
Ø1.13	+0.012/-0.001	1.127	✓			
Ø0.500	+0.000/-0.005	.497	✓			
Ø0.500	+0.000/-0.005					
R0.25	+/-0.030	R0.25"	✓			
.450"	±.010"	.447"	✓			
.625"	±.010"	0.630	✓			
.063x45°	±.010"	.065"x45°	✓			
Ø.129	±.005"	0.129	0.129 ✓			
.263"x45°	±.010"	.263"x45°	✓			

All ready there

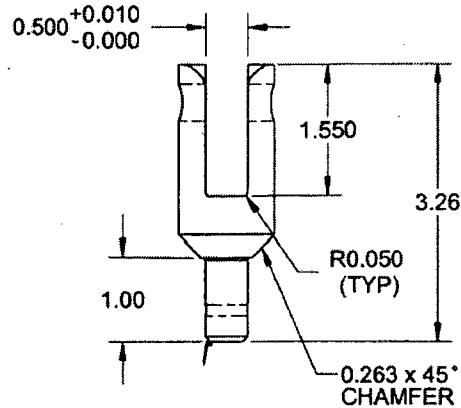
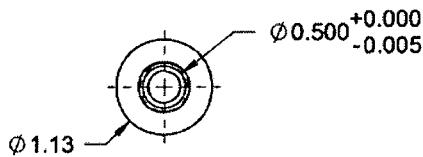
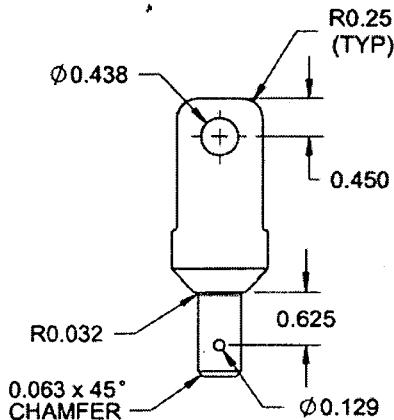
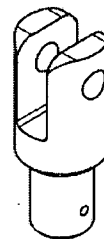
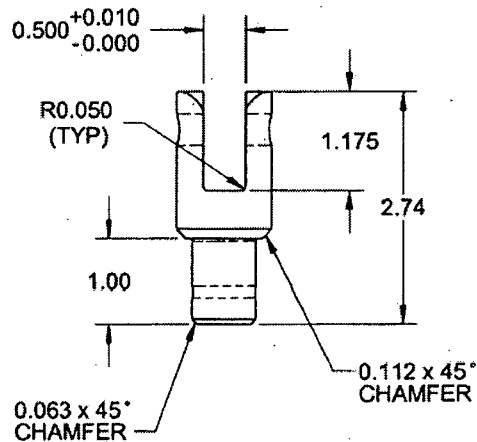
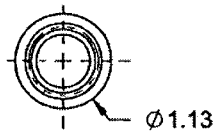
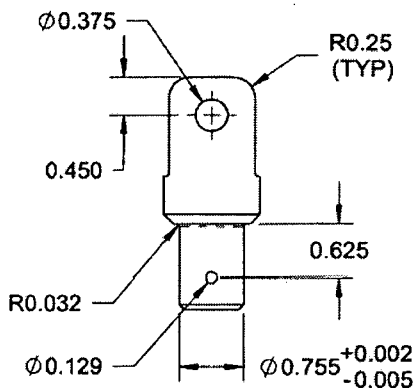
Measured by: J.F.F.	Audited by: J.G.	Prototype Approval:	N/A
Date: 06/12/05	Date: 06/12/12	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	06.06.30	New Issue	KJ/JLM	

[Handwritten signature]

DART

DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3453	REV. A SHEET 1 OF 2
DATE 05.09.02	TITLE CLEVIS		SCALE 12
A	05.09.02	NEW ISSUE	

**D3453-1 CLEVIS****RELEASED**05.12.09 *[Signature]***D3453-3 CLEVIS****NOTES:**

- 1) MATERIAL: AISI 304 SS ROUND BAR (REF. DART SPEC M304R)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.010

SHOP COPY
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WITHOUT NOTICE
WORK ORDER
NO. **29677**

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